DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

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Contract #: 04-0120F4

Cty: SF/Ala Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-010051 Address: 333 Burma Road **Date Inspected:** 31-Oct-2009

City: Oakland, CA 94607

OSM Arrival Time: 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: See below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower and OBG Components

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

SAW welding of weld joint SSTL4-1B/L-4A located outside PCMK south tower, lift 4, skin A to skin B, between approximately the 138M mark and the 144M mark. Welder was identified as 050295. ZPMC QC was identified as CWI Wan Wen Zhong (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint SSTL4-1B/L-4A located outside PCMK south tower, lift 4, skin A to skin B, between approximately the 122M mark and the 128M mark. Welder was identified as 040489. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-B-L2c-S-2.

SAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, between approximately the 130M mark and the 136M mark. Welder was identified as 207745. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2.

SAW welding of weld joint SSTL4-1B/L-5A located outside PCMK south tower, lift 4, skin B to skin C, from the bottom of lift 4 to approximately the 120M mark. Welder was identified as 201750. ZPMC QC was identified as

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QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2221-C-U2b-S-2.

SAW welding of weld joint SSTL4-1L/L-4A located outside PCMK south tower, lift 4, skin A to skin B, between approximately the 144M mark and 100mm of the top of lift 4. Welder was identified as 040252. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3221-B-L2c-S-2.

SMAW welding of weld joint SSTL4-1L/L-1B located inside PCMK south tower, lift 4, skin D to skin E, between approximately the 144M mark and the top of lift 4. Welder was identified as 052493. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3211-TC-U4b-1.

Bay 9 – PMT

This QA Inspector monitored OBG Production Monitoring Test (PMT) #3041 for deck panels DP3041-001 and DP3062-001 at Gantry #2. Prior to the start of the PMT, this QA Inspector observed the root opening to be within the 0.0 to 0.5mm tolerance. The magnetic particle test (MT) of the tack welds was noted on the test panel as having been performed by ZPMC MT Inspector Ding A Cheng on 10/31/09. The visual inspection of tack welds and root gap was performed by ABF Representative Cao Hai Zhou (ABF), ZPMC CWI Sun Bo (QC), and this QA Inspector. The tack welds and root gap appeared to be within prescribed tolerances. This QA Inspector observed that the deck plate of the test panel was 20mm thick and the production panels DP3041-001 and DP30362-001 were 14mm and 20mm thick respectively. The start time for welding of the 3–12mm x 20mm specimens was approximately 0023 hours on 11/1/09 and the finish time was approximately 0054 hours. This QA Inspector randomly verified and documented the welding amperage, voltage, and travel speed during the gas metal arc welding (GMAW) and submerged arc welding (SAW) processes, welds 1 thru 6 at the completion of both the GMAW root pass and SAW cover pass. The welding variables recorded by QC appeared to comply with WPS-B-T-2342-U1-(U-rib)-4. The welds were visually inspected by ABF, QC and this QA Inspector. QC and ABF informed this QA Inspector that all six welds were acceptable and this QA Inspector concurred. This QA inspector randomly witnessed ZPMC ultrasonic testing (UT) inspector, identified as Ma Jilong, perform UT on each of the 500 mm test welds for depth of penetration and conformance. This QA Inspector selected fifteen designated locations for macroetch sampling per contract requirements. Each macroetch location was stamped by ZPMC personnel with the number 3041, the letter M, and an individual macroetch identifying number for each macroetch. After removal from each of the weld test specimens, polishing, and acid etching of the selected end, the macroetches were evaluated with a 7X optical magnifier and accepted by QC, ABF, and this QA Inspector.

All fifteen sample macros appeared to meet requirements and were noted to appear acceptable. See Caltrans U-ribs PMT Inspection Sheet, ZPMC production monitoring test plate inspection report, and Caltrans Macro Etch Log - all dated 11/1/2008 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Dawson,Paul	QA Reviewer